

Work Order ID 51690

August 27, 2009 12:01:47 PM



Page 1

Item ID: D407-547-047 **BK**

Accept



Setup Start



Revision ID: F

Stop



Item Name: Console High Slope

Start Date: 8/28/09 Start Qty: 6.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D206-547

Rev F

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4 2-Debur

PL 09.09.09

110

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

2> 8/29/09

(X6U1 X6RH)

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Grind weld relief chamfer as per Dwg D206-547 3-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

EP 09/09/16 (62)

2- Clean rails with ultra bright Alum. cleaner before riveting.

8/29/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 51690

August 27, 2009 12:01:47 PM

Page 2

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

130 QC5- Inspect part completeness to step on W/O

0.00

=> 8/28/09

X6RH

X6LH



QC

Memo

0.00

Quality Control

140 Large Fab 0.00



Large Fab

Large Fab

Memo

0.00

1-Weld as per Dwg D206-54711A/R

AL ROD

Batch: 1111385

12-Grind weld as per dwg D206-547

SP

09.09.21

150 QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

X6LH

X6RH

BE 09/09/25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 51690

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Page 3

Item ID: D407-547-047

Accept



Setup Start



Revision ID: F

Item Name: Console High Slope

Stop



Start Date: 8/28/09 Start Qty: 6.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

160

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

09/09/28 (46)

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27805/0226

(46)

180

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M1109091

27 09/09/29

(46)

START TIME: 8:15AM FINISH TIME: 8:45AM OVEN TEMPERATURE: 320°F

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 51690

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Item ID: D407-547-047

Accept

Revision ID: F

Item Name: Console High Slope

Start Date: 8/28/09 Start Qty: 6.00

Required Date: 9/04/09 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

BR 09-09-29

⑥

PP
5/6 58

10/9/29 ⑥

09/09/29
W 09-09-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51690

Parent Item: D407-547-047RevF

Parent Item Name: Console High Slope

Comments:

Start Date: 8/28/09

Required Date: 9/04/09

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2024RevU/R | | Manufactured | No | | | 120 | f | 0.0000 | 21.6000 | | | |
| Console Extrusion | | | | | | | | | | | | |
| D2604-1RevB | | Manufactured | No | | | 120 | Each | 14.0000 | 6.0000 | | | |
| Console Side LH, 407 Console | | | | | | | | | | | | |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 14 | |
| 34778 | 1 | |
| 38264 | 1 | |
| 51301 | 12 | |

| | | | | | | | | | | | | |
|------------------------------|--|--------------|----|--|--|-----|------|---------|--------|--|--|--|
| D2604-2RevB | | Manufactured | No | | | 120 | Each | 14.0000 | 6.0000 | | | |
| Console Side RH, 407 Console | | | | | | | | | | | | |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 2 | |
| 34779 | 2 | |
| Main Warehouse | | |
| ST177 | 12 | |
| 50248 | 12 | |

Cpl 09.08.31

6 Cpl 09.08.31

6 Cpl 09.08.31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51690

Parent Item: D407-547-047RevF

Parent Item Name: Console High Slope


Comments:

Start Date: 8/28/09

Required Date: 9/04/09

Start Qty: 6.00


Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2606RevA1  Console Bracket, 206/407 Console | | Manufactured | No | | | 120 | Each | 25.0000 | 6.0000 | | | |

Ep 09/08/28

| <u>Warehouse</u> | <u>Loc</u> | <u>Qty</u> | <u>Loc Code</u> |
|------------------|------------|------------|-----------------|
| <u>Location</u> | | | |
| Main Warehouse | | | |
| ST | | 25 | |
| 48442 | | 25 | |


6

| | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|---------|--------|--|--|--|
| D2608RevA1  Bracket, 407 Console | | Manufactured | No | | | 120 | Each | 23.0000 | 6.0000 | | | |
|--|--|--------------|----|--|--|-----|------|---------|--------|--|--|--|

| <u>Warehouse</u> | <u>Loc</u> | <u>Qty</u> | <u>Loc Code</u> |
|------------------|------------|------------|-----------------|
| <u>Location</u> | | | |
| Main Warehouse | | | |
| ST | | 23 | |
| 35661 | | 23 | |

Ep 09/09/28

6

| | | | | | | | | | | | | |
|---|--|-----------|----|--|--|-----|------|-----------|---------|--|--|--|
| MS20470AD3-3  Rivet, Universal Head | | Purchased | No | | | 120 | Each | 8,658.000 | 36.0000 | | | |
|---|--|-----------|----|--|--|-----|------|-----------|---------|--|--|--|

| <u>Warehouse</u> | <u>Loc</u> | <u>Qty</u> | <u>Loc Code</u> |
|------------------|------------|------------|-----------------|
| <u>Location</u> | | | |
| Main Warehouse | | | |
| ST | | 8658 | |
| 1065 | | 1435 | |
| 16941 | | 7223 | |

Ep 09/09/28

36

August 27, 2009 12:01:46 PM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51690



Parent Item: D407-547-047RevF



Parent Item Name: Console High Slope

Start Date: 8/28/09

Required Date: 9/04/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS20470AD3-4 | | Purchased | No | | | 120 | Each | 12,283.00 | 120.0000 | | | |



Rivet, Universal Head



9/09/09/16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12283

111477

8332

15541

3951

120

August 27, 2009 12:01:46 PM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED UP | APPROVED KE | DRAWING NO. D206-547 | REV. F SHEET 1 OF 5 |
| DATE 99.02.11 | | TITLE CONSOLE ASSEMBLY | SCALE NTS |
| - | 82.11.23 | NEW ISSUE | |
| A | 83.01.18 | REDRAWN, ADD NOTE 4 | |
| B | 84.10.23 | D206-547 WAS 01.B.81.017 | |
| C | 89.03.30 | REDRAWN | |
| D | 90.12.06 | COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85 | |
| E | 97.10.22 | REDRAWN, ADD -043,-045,-047 | |
| F | 99.02.11 | ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL | |

RELEASED
R 99.03.05 RE

| -041 | -043 | -045 | -047 | PART NUMBER | DESCRIPTION |
|------|------|------|------|--------------|-------------------|
| X | | | | D206-547-041 | CONSOLE ASSEMBLY |
| | X | | | D206-547-043 | CONSOLE ASSEMBLY |
| | | X | | D407-547-045 | CONSOLE ASSEMBLY |
| | | | X | D407-547-047 | CONSOLE ASSEMBLY |
| | | | | | |
| 1 | | | | D2601-1 | CONSOLE SIDE |
| 1 | | | | D2601-2 | CONSOLE SIDE |
| | 1 | | | D2602-1 | CONSOLE SIDE |
| | 1 | | | D2602-2 | CONSOLE SIDE |
| | | 1 | | D2603-1 | CONSOLE SIDE |
| | | 1 | | D2603-2 | CONSOLE SIDE |
| | | | 1 | D2604-1 | CONSOLE SIDE |
| | | | 1 | D2604-2 | CONSOLE SIDE |
| 1 | | 1 | | D2605 | CONSOLE BRACKET |
| | 1 | | 1 | D2606 | CONSOLE BRACKET |
| 1 | 1 | | | D2607 | CONSOLE BRACKET |
| | | 1 | 1 | D2608 | CONSOLE BRACKET |
| 1 | | 1 | | D2709-1 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-2 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-3 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-4 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-1 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-2 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-3 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-4 | CONSOLE SIDE RAIL |
| | | | | | |
| 10 | 8 | 8 | 6 | MS20470AD3-3 | RIVET |
| 18 | 20 | 18 | 20 | MS20470AD3-4 | RIVET |
| | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

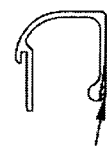
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

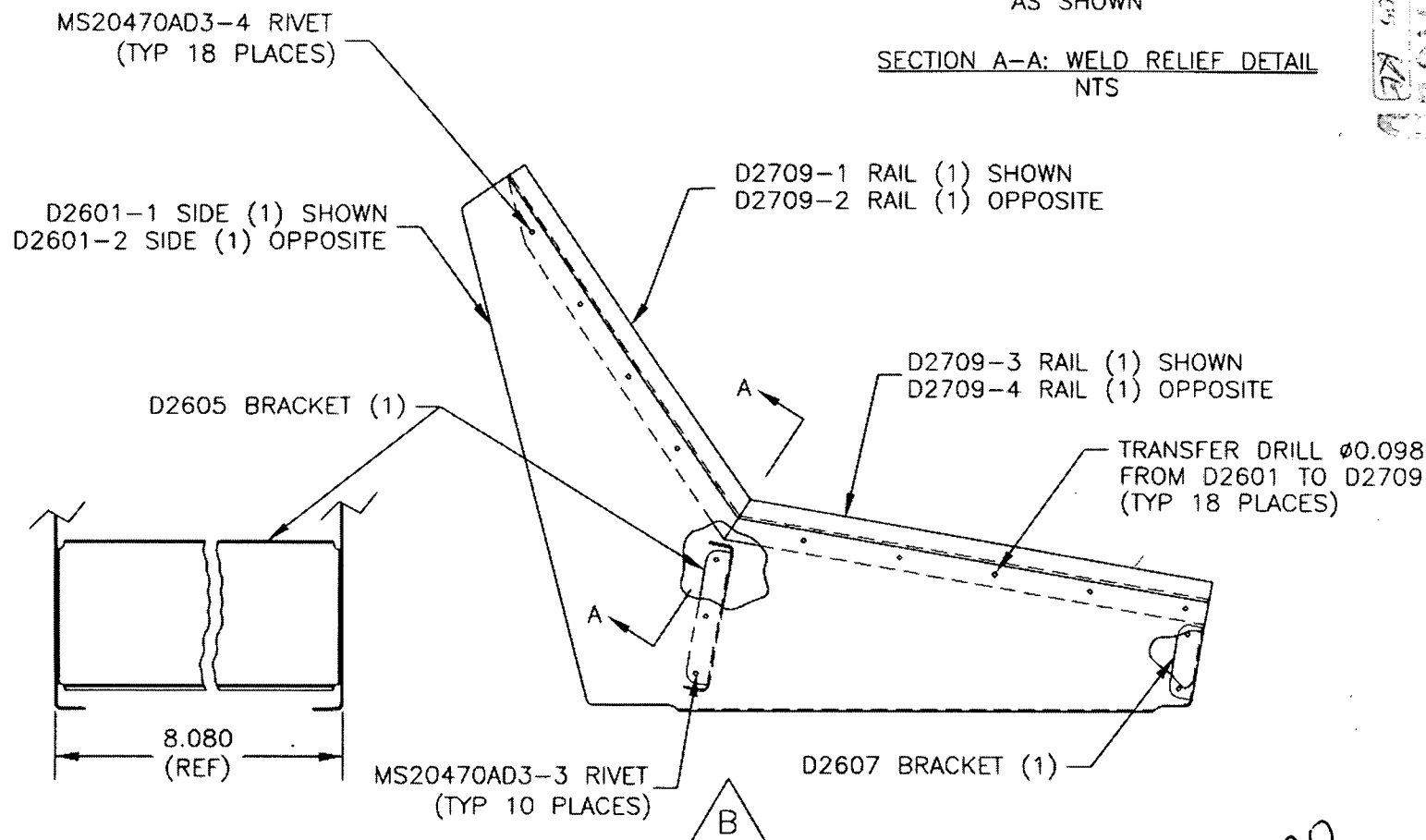


RELEASED
99.02.11 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | | |
|---------|----------|----------|------------------|---|
| DESIGN | BW | DRAWN BY | RT | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | JP | APPROVED | KE | |
| DATE | 99.02.11 | TITLE | D206-547 | SHEET 2 OF 5 |
| | | | CONSOLE ASSEMBLY | SCALE 1:4 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

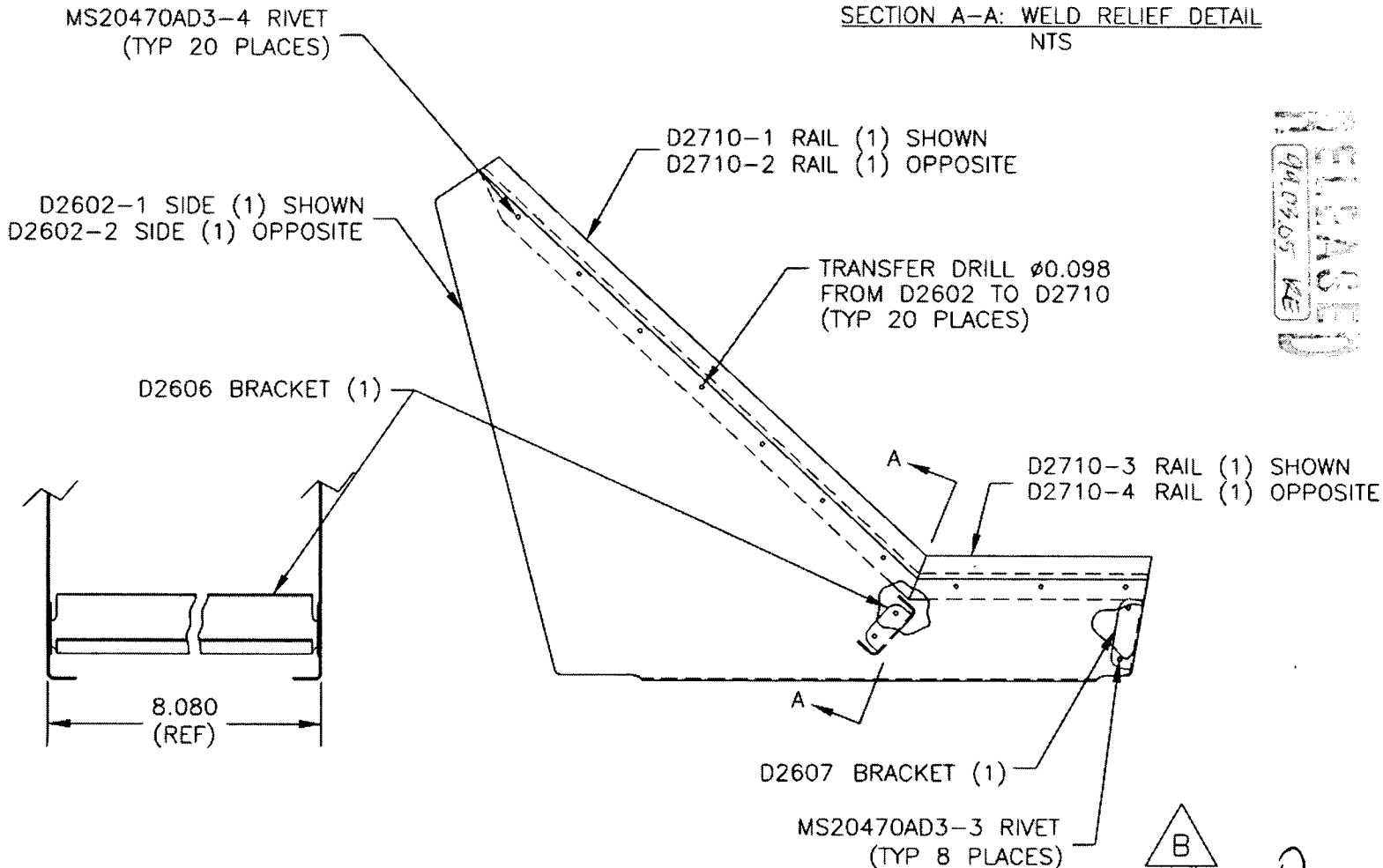
DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS

RELEASED
940305 KE



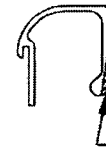
D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

56915

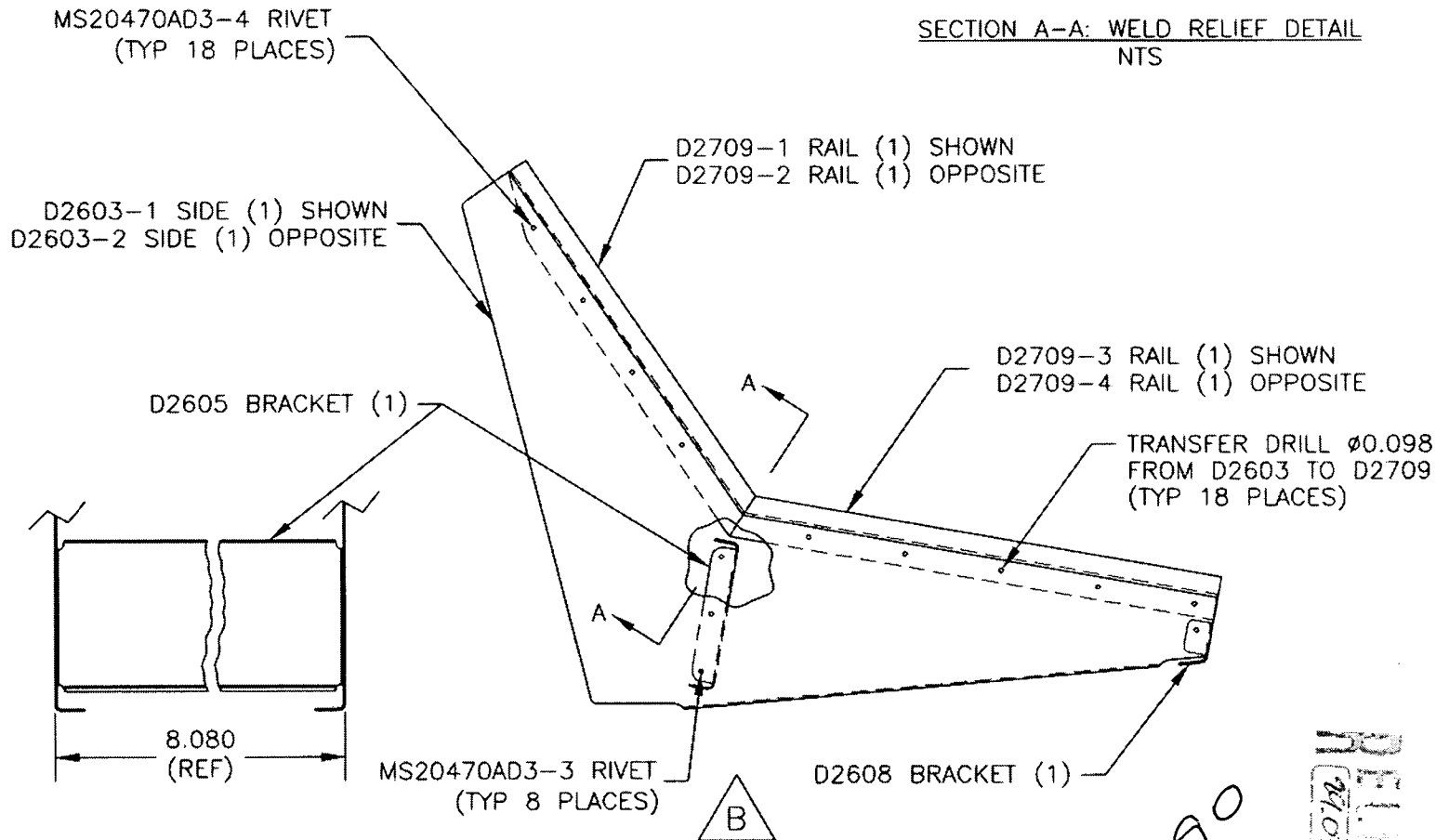
| | | | | |
|---------|----------|----------|------------------|---|
| DESIGN | BW | DRAWN BY | KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | UP | APPROVED | KE | |
| DATE | 99.02.11 | TITLE | D206-547 | REV. F |
| | | | CONSOLE ASSEMBLY | SHEET 3 OF 5 |
| | | | | SCALE 1:4 |

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

56915

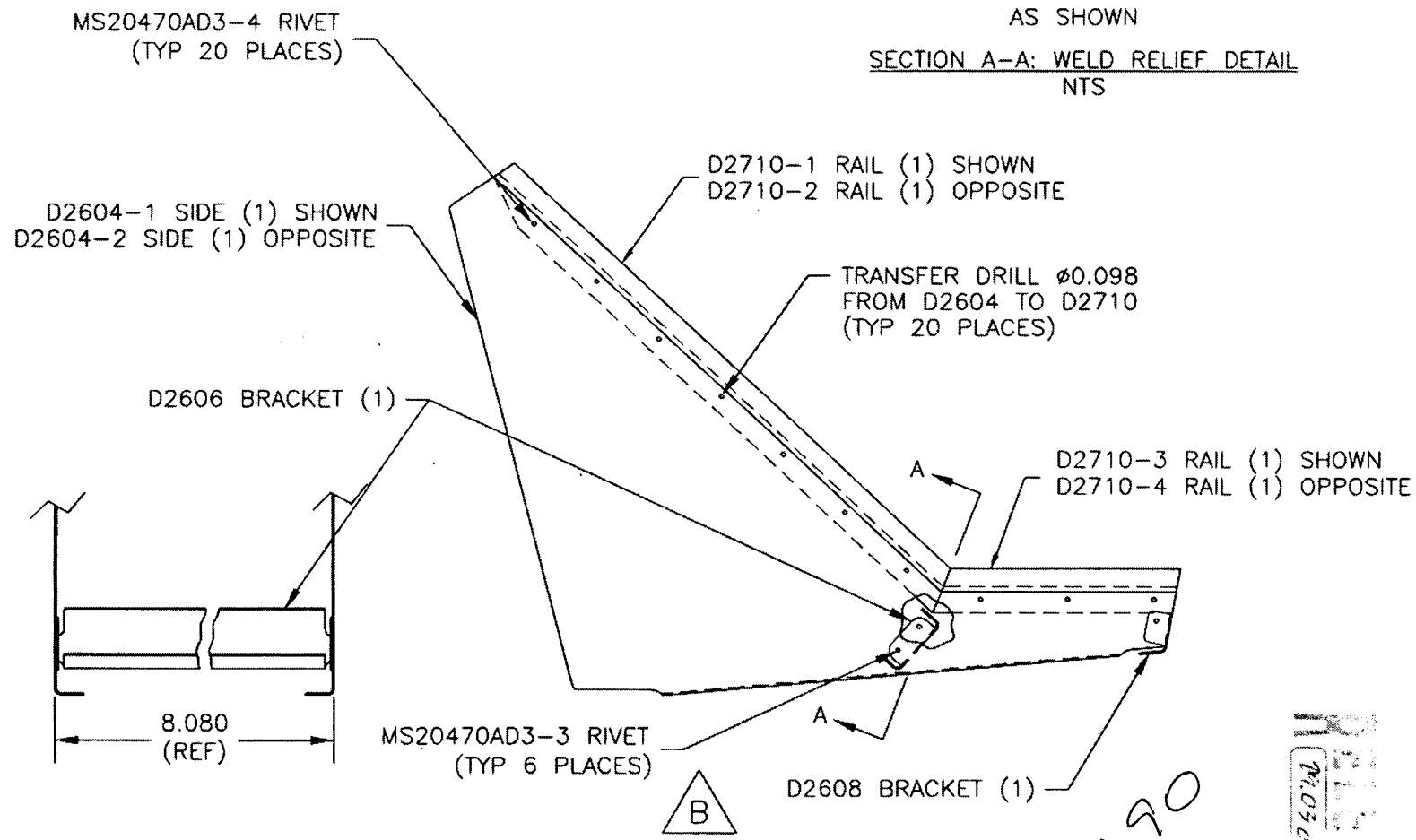
RELEASED
21/03/07 KE

| | | |
|------------------|---------------------------|---|
| DESIGN BW | DRAWN BY T.T. | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED KE | APPROVED KE | DRAWING NO. D206-547 |
| DATE 99.02.11 | TITLE CONSOLE ASSEMBLY | REV. F SHEET 4 OF 5 |
| | SCALE 1:4 | |



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|------------------|----------------|---|--------------|
| BW | KE | DRAWING NO. | REV. F |
| CHECKED CP | APPROVED KE | D206-547 | SHEET 5 OF 5 |
| DATE 99.02.11 | | TITLE CONSOLE ASSEMBLY | SCALE 1:4 |